

Date: Wednesday, 9/13/2006 4:20:49 PM  
 User: Kim Johnston

## Process Sheet

*split*  
*SB 06/11/06*

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : PILOT/CO-PILOT STEP, RH (FOLDING)  
 Job Number : 28508  
 Estimate Number : 10824  
 P.O. Number : *NIA* Part Number : D412630032  
 This Issue : 9/13/2006 S.O. No. : *NIA* Drawing Number : D412-630 REV.J, P17  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : *NA* Type : LARGE FAB ASSY Drawing Revision : J  
 Previous Run : 28153 Material : *NIA*  
 Due Date : 10/10/2006 Qty: 3 Um: Each  
 Written By : *[Signature]*  
 Checked & Approved By : *[Signature]*  
 Comment : EST. REV. A 05.11.21 NEW ISSUE EC  
 EST. REV. B 05.12.19 updated pick list EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy D412-630 bluefile &amp; type labels per PPP412-630-031 CHG001

2.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

Assemble as per dwg D412-630 p.17

*SB 06/11/07 ①*

3.0 D3463042 Step Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3463-042	Step weldment	<i>B28176</i>

4.0 D3443043 Strut Weldment Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3443-043	Strut ass'y	<i>B28529</i>

5.0 D3443041 Strut Weldment Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3443-041	Strut ass'y	<i>B28527</i>

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Job Number: 28508

Part Number: D412630032

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	D34439	PIN
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3443-9	Pin	B28164

7.0	AN4CH3	SS Bolt
-----	--------	---------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	AN4CH3	BOLT	N19390
A/R	MS20995c25e	Lockwire	N101537

8.0	AN4C14	BOLT
-----	--------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	AN4C14	BOLT	N19096

9.0	D34547	Bushing
-----	--------	---------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3454-7	Bushing	B28170

10.0	AN3104	NUT
------	--------	-----



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	AN310-4	Nut	N19096

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Part Number: D412630032

Job Number:



Seq. #: Machine Or Operation: Description :

11.0 MS24665227 COTTER PIN



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	MS24665-227	COTTER PIN	M19096

12.0 D34551 Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3455-1	Spacer	B28171

13.0 D34651 Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3465-1	Washer	B25536

14.0 AN3107 NUT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	AN310-7	Nut	M19096

15.0 MS24665302 Cotter Pin



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	MS24665-302	COTTER PIN	M16941

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Job Number: 28508

Part Number: D412630032

Job Number:



Seq. #: Machine Or Operation: Description :

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DA06/11/07 (1)

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

18.0

D34541

Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

✓ 1

D3454-1

Bushing

B28167 \*

19.0

D34543

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

✓ 2

D3454-3

Bushing

B28168 -

20.0

D34545

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

✓ 2

D3454-5

Bushing

B28169 -

21.0

D34551

Spacer



Comment: Qty.: 6.0000 Each(s)/Unit Total: 18.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

✓ 6

D3455-1

Spacer

B28171 -

## Process Sheet

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Job Number: 28508

Part Number: D412630032

Job Number:



Seq. #:	Machine Or Operation:	Description :
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22.0	D34553	Spacer
------	--------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
✓ 2	D3455-3	Spacer	B28172 -

23.0	D3462042	Bracket Assembly
------	----------	------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
✓ 1	D3462-042	Bracket ass'y	B28472 -

24.0	AN3104	NUT
------	--------	-----



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
✓ 2	AN310-4	Nut	M19096 -

25.0	AN3105	NUT
------	--------	-----



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
✓ 2	AN310-5	Nut	M19096 -

26.0	AN3C5A	Bolt
------	--------	------



Comment: Qty.: 3.0000 Each(s)/Unit Total : 9.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
✓ 3	AN3-C5A	Bolt	M102404 -

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Job Number: 28508

Part Number: D412630032

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

AN44C12

eyebolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

✓ 1

AN44-C12

Eyebolt

M19649 -

28.0

AN4C15

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

✓ 1

AN4C15

BOLT

M19213 -

29.0

AN5C11

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

✓ 1

AN5C11

BOLT

M19096 -

30.0

AN5C15

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

✓ 1

AN5C15

BOLT

M19213 -

31.0

AN960C10

WASHER



Comment: Qty.: 7.0000 EACH(s)/Unit Total : 21.0000 EACH(s)

Pick:

Qty

Part Number

Description

Batch

✓ 7

AN960C10

Washer

M101064



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Job Number: 28508

Part Number: D412630032

Job Number:



Seq. #:

Machine Or Operation:

Description:

32.0

AN960C516

WASHER



Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

✓ 1

AN960C516

Washer

M17697-

33.0

MS210433

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total: 9.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

✓ 3

MS21043-3

Nut

M102404-

34.0

MS24665227

COTTER PIN



Comment: Qty.: 2.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

✓ 2

MS24665-227

COTTER PIN

M19096  
M102073-

35.0

MS24665229

COTTER PIN



Comment: Qty.: 2.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

✓ 2

MS24665-229

COTTER PIN

M19096

36.0

NAS1515H5

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

✓ 1

NAS1515H5

Washer

M101064

206/11/08 (1)

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Part Number: D412630032

Job Number:



Seq. #:

Machine Or Operation:

Description :

37.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
Assemble as per dwg D412-630 p.17

38.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP  
Test fit on aircraft in Eng. lab.

39.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

40.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Identify and pack for shipping as per PPP D412-630-031  
Location: \_\_\_\_\_  
PPP Rev: DART

41.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion





FIGURE 20 – Isometric View D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown)  
D412-630-031 LH (Opposite)

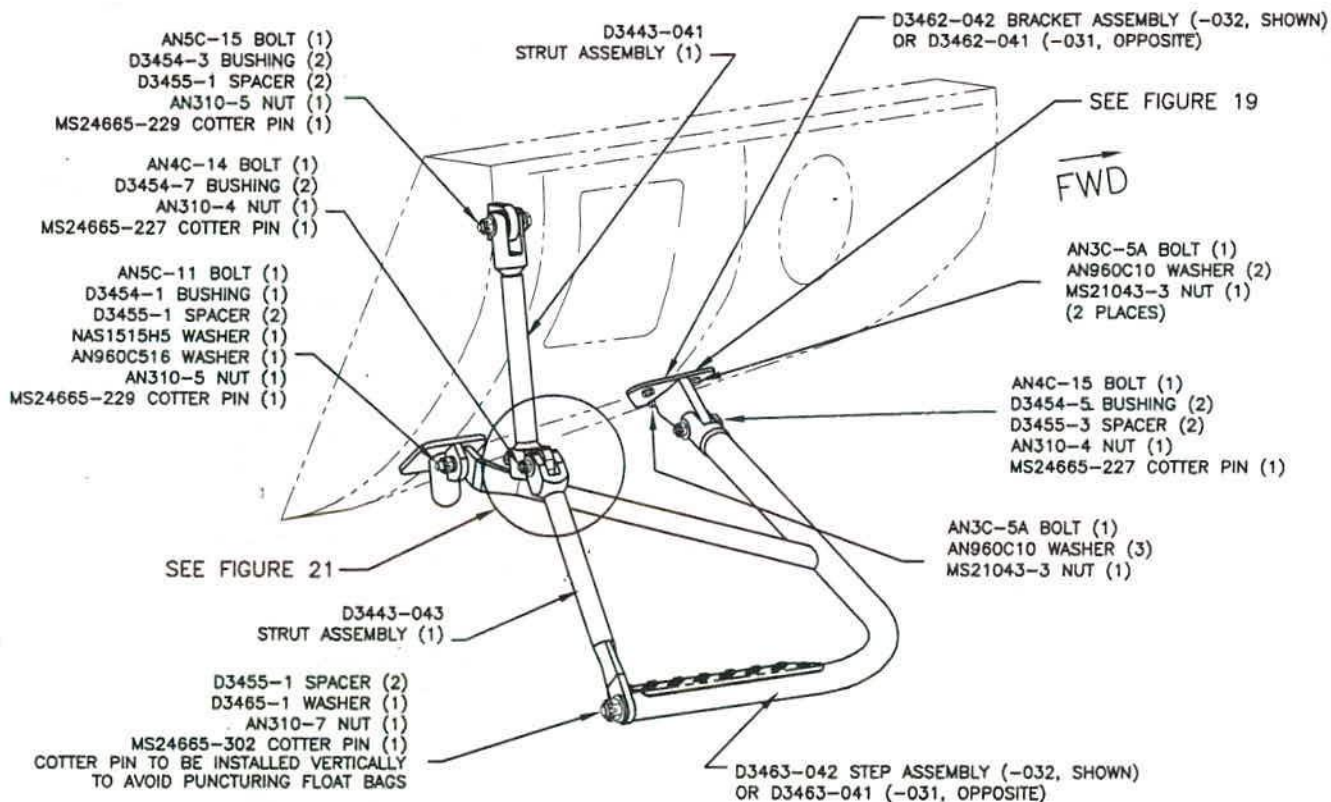
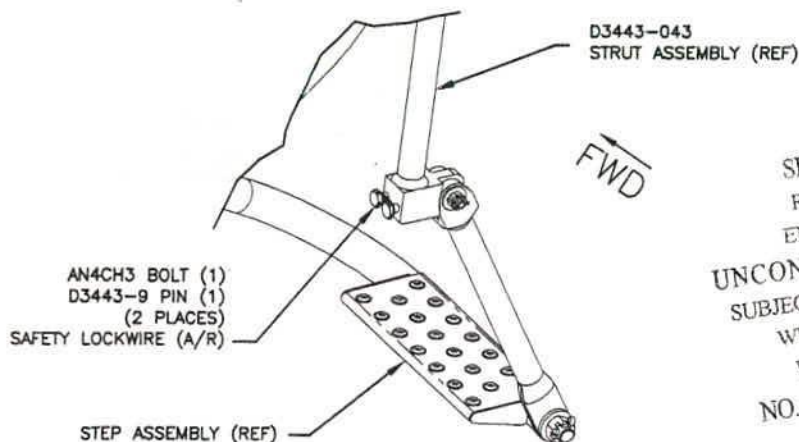


FIGURE 21 – Detail Safety Wiring, D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown)  
D412-630-031 LH (Opposite)



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